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D2721-042
Job Sheet 167885



Part No: D2721-042

Job Qty: 2 ea

Part Name: 206B Step Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/7/17

Job Tracking No:

Due Date: 12/11/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		12/8/17	0.00	0.00	Start Up Large Fab2		
100	Large Fab	2 pcs		12/8/17	0.00	4.15	Large Fab 8		
110	Large Fab	2 pcs		12/9/17	0.00	4.15	Large Fab 8		OK NOV 28 2017
120	QC	2 pcs		12/9/17	0.00	0.00			
120	QC	2 pcs		12/9/17	0.00	0.00	QC9		PD 17-12-01
130	QC	2 pcs		12/9/17	0.00	0.00	QC5		PD 17-12-01
140	HandFinish	2 pcs		12/9/17	0.00	0.47	HandFinish1		2017-12-04 JSC
150	QC	2 pcs		12/9/17	0.00	0.00			DAS
150	QC	2 pcs		12/9/17	0.00	0.00	QC3		38
160	Large Fab	2 pcs		12/9/17	0.00	4.15	Large Fab 8		11 17-12-06
170	QC	2 pcs		12/9/17	0.00	0.00	QC9		PD 17-12-08
180	QC	2 pcs		12/9/17	0.00	0.00	QC5		PD 17-12-08
190	HandFinish	2 pcs		12/9/17	0.00	0.47	HandFinish1		2017-12-08 JSC
200	Powdercoat	2 pcs		12/9/17	0.00	0.29	Powdercoat1		BK 17-12-11
210	QC	2 pcs		12/9/17	0.00	0.00	QC3		BEB 17-12-13
220	HandFinish	2 pcs		12/11/17	0.00	0.47	HandFinish3		BEB 17-12-13
230	QC	2 pcs		12/11/17	0.00	0.00	QC3		38
240	Packaging	2 pcs		12/11/17	0.00	0.00	Packaging3		SMB
250	QC21-SA	2 Ea		12/11/17	0.00	0.00	QC21		DEC 15 2017

Part Op 100 - Cut D2721-2 using D2622 extrusion as per Dwg D2721 Deburr and bevel ends for welding DRILL VENT HOLE AS
Descriptions: PER SECTION A-A

110 - Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT10235 A followed by Jig DT10235B A/R AL
Rod Batch: _____ Grind end cap welds flush

160 - Inspect for foreign object per QSI 024 Weld Remaining end cap as per Dwg D2721 BLOCK VENT HOLE USING
RIVET AS PER DWG A/R AL Rod Batch: _____ Grind End Cap Welds Flush

200 - START TIME: 4:30 OVEN TEMPERATURE: 350° FINISH TIME: 5:00

M 138467

wing walk M138373

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2622-120C 1624842	2	12	0	0
110-Large Fab	D2734 5008231	2	14	0	0
	D3461-1 F58756	2	9	0	0
	D3461-3 F126300	2	5	0	0
	D3461-5	2	23	0	0
	D3461-7 F107696	2	12	0	0
	MS20601-AD4W2	2	113	0	0

F142383

F1138336-7

Part Specifications

Specifications could not be found.

Plex 11/7/17 2:33 PM Dart.lajeunesse.marie

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S012304

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**206B Step Assembly****PART NO:****D2721-042****Revision:****Operation:****Start up Operation****Change No:****Mfg Date: 11/22/17****Job No: 167885**